

Work Order ID 139888

December 11, 2015 1:36:42 PM

139888

Stop Dec 15 2015
Not for this year.
Can put in stock

Item ID: D407-559-115 Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Stop *NS2*

Start Date: 12/11/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 12/15/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: *34* Date: *20151211* Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9624	REV A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels per PPP D407-559-115 CHG001								
151	Pick Kit	0.00							
151									
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									

*DAS
8
9-89*

MCS

DEC 14 2015

*DAS
28
9-89*

DEC 14 2015

see attachment

*DAS
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9-89*

DEC 11 2015

*DAS
27
9-89*

DEC 14 2015

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28
9-89*

DEC 14 2015

Work Order ID 139888***139888***

Page 2

December 11, 2015 1:36:42 PM

Item ID: D407-559-115

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 12/11/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/15/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170 Identify as per dwg & Stock Location: FG13 0.00***170***

Packaging Memo 0.00

Packaging

1X DAS
28
9-89 DEC 14 2015

180 QC21- Final Inspection - Work Order Release 0.00

180

QC Memo 0.00

Quality Control

ML5 DEC 14 2015ML5 DEC 14 2015

Picklist Print

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Page 1

Work Order ID: 139888

139888

Parent Item: D407-559-115

D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 12/11/2015

Required Date: 12/15/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-07-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2274

Manufactured

No

Each

64.0000

12

D2274

Radius Block

**

BAS

27

9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

52

136201

52

D2529

Manufactured

No

Each

363.0000

12

D2529

Washer

**

BAS

27

9-89

Location

Loc Qty

Loc Code

ST008

363

137534

363

D2432-3

Manufactured

No

Each

2.0000

2

D2432-3

206 (24") Bearpaw

**

BAS

27

9-89

Location

Loc Qty

Loc Code

ST470A

2

136972

2

D4011-1

Manufactured

No

Each

40.0000

6

D4011-1

Clamp, Short

**

BAS

27

9-89

Location

Loc Qty

Loc Code

ST544

40

138243

40

DAS
28
9-89

DAS
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DAS
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DAS
28
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Picklist Print

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Page 2

Work Order ID: 139888

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Parent Item: D407-559-115

D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 12/11/2015

Required Date: 12/15/2015

Start Qty: 1.00

Required Qty: 1.00

D4012-1

Manufactured No

Each 7.0000

D4012-1

Cushion

****** 6 137697 *sl*

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

133458

5

ST545

2

133458

2

AN4-20A

Purchased No

Each 184.0000

12

AN4-20A

Bolt

DAS
8
9-89

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DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

24

m116419

24

ST325A

100

m132680

100

ST343

60

m127290

8

m132617

2

m133694

50

8
24

Picklist Print

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Parent Item: D407-559-115

D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 12/11/2015

Required Date: 12/15/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

2,886.000

12

NAS1149D0463.J

WASHER

DAS

27

8-89

DEC 11 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	432	
M129390	41	
M132035	391	
ST263	1020	
M133284	42	
<u>M133316</u>	978	12
ST269	1434	
M129682	39	
M130799	371	
M132317	101	
M132677	888	
M133077	35	

Picklist Print

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Parent Item: D407-559-115

D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 12/11/2015

Required Date: 12/15/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

3,495.000

12

MS21042L 4

DAS

DAS

Locknut

27

27

9-89

9-89

DEC 11 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

139

m124231

2

m133363

137

GA

49

m127813

49

ST260a

138

m130799

56

m131803

6

m132262

76

ST303

3000

m133769

3000

ST305

169

m128300

8

m130388

7

m130922

97

m132123

56

m133316

1

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-559 Rev. L AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-559 REV. 3

REF CANADIAN STC: SH92-17

REF FAA STC: SH1031NE

REF LBA STC: 0796/3034

REF JCAB STC: STC-90-TYO

REF BRAZIL STC: 2010S10-08

20151211

SH 139888

1.0 PURPOSE

The purpose of this Dart Service Instruction is to add the D407-559-115 Bearpaw Kit to this approval. The D407-559-115 Bearpaw Kit is designed to be compatible with D206-642-311/-312/-313/-314/-411/-412/-413/-414 Skidtubes equipped with D206-642-XXX Run-On Landing Wearplates. The D407-559-115 Bearpaw Kit is also compatible with the D206-642-XXX Skidtubes equipped with standard wearplates/wearshoes.

2.0 INSTALLATION

To install D407-559-115 Bearpaw Kit on Dart D206-642-XXX Skidtubes equipped with D206-642-XXX Run-On Landing Wearplates refer to Figures 1 & 2 of this Service Instruction as well as the following:

- 2.1 Jack up the aircraft and ensure the skidtubes are serviceable in accordance with ICA-D206-642.
- 2.2 Position D2432-3 Bearpaw on the aft end of each skidtube so that the bearpaw clamps are located on either side of the aft saddle as shown in Figure 1a - 1c of this Service Instruction. The bearpaws should be installed over the run-on landing wearplates.
- 2.3 Attach the D4011-1 Clamps with D4012-1 Cushions using hardware shown in Figure 2 of this Service Instruction. Additional AN960JD416 (or NAS1149D0463J) washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-20A bolts with longer or shorter AN4 bolts, if required.

CAUTION: The torque on the nuts should be limited to 20 in-lb (2.3 Nm)

- 2.4 Lower the aircraft.
- 2.5 Update the aircraft log book to indicate installation of the D407-559-115 Bearpaw Kit and adjust the empty weight and balance record for the rotorcraft with the information given in section 5.0 of this service instruction.

3.0 MAINTENANCE

The D407-559-115 Bearpaw Kit should be maintained in accordance with ICA-D206-559.

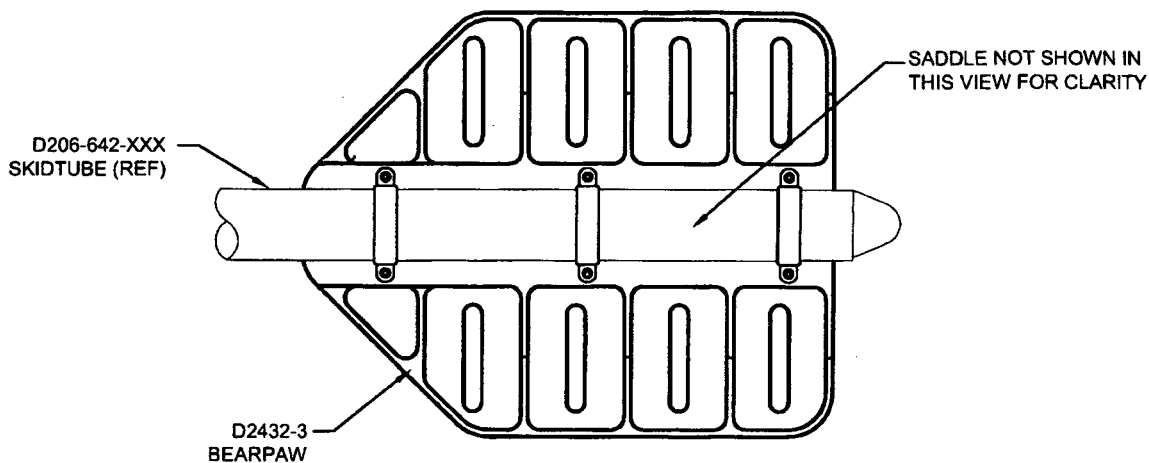
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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

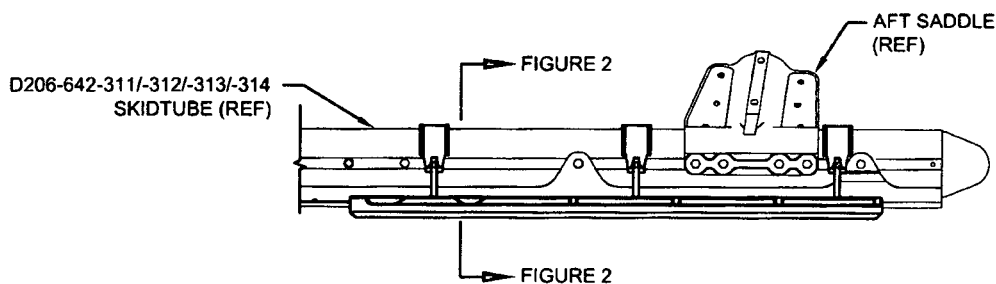
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.07.05
CERT. NO.: SH92-17
ISSUE NO.: 7

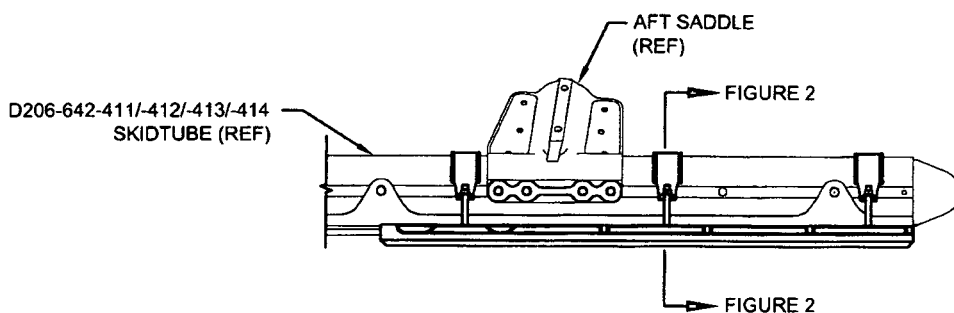
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MFG. APPR.	N/A	DSI 9624	SHEET 1 OF 4
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DE APPR.	<i>[Signature]</i>	BEARPAW INSTALLATION	NTS
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**Figure 1a - Bearpaw Location
(Top View)**



**Figure 1b - Bearpaw Installation (Side View)
(Installed on D206-642-311/-312/-313/-314 Skid tubes)**



**Figure 1c - Bearpaw Installation (Side View)
(Installed on D206-642-411/-412/-413/-414 Skid tubes)**

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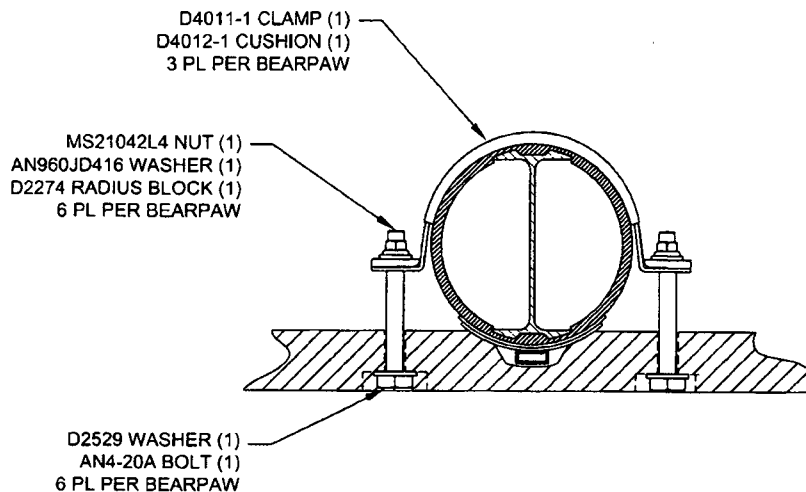


Figure 2 - D4011-1 Clamp Installation

4.0 PARTS LIST

QTY -115	PART NUMBER	DESCRIPTION
	D407-559-115	BEARPAW INSTALLATION
12	D2274	RADIUS BLOCK
12	D2529	WASHER
2	D2432-3	BEARPAW
6	D4011-1	CLAMP
6	D4012-1	CUSHION
12	AN4-20A	BOLT
12	AN960JD416	WASHER (NAS1149D0463J)
12	MS21042L4	NUT

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5.0 WEIGHT AND BALANCE

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D407-559-115 Bearpaw installation (Bell 407 High Gear)	13.9 lb 6.30 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	148 in 3.76 m	2057 in-lb 23.69 m-kg
D407-559-115 Bearpaw installation (Bell 206L/407 Low Gear)	13.9 lb 6.30 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	149 in 3.78 m	2071 in-lb 23.81 m-kg
D407-559-115 Bearpaw installation (Bell 206 L High Gear)	13.9 lb 6.30 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	157 in 3.99 m	2182 in-lb 25.14 m-kg

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Ship Dec 15

Work Order ID 139888

139888

December 11, 2015 1:36:42 PM

Item ID: D407-559-115 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible
Start Date: 12/11/2015 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 12/15/2015 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: 34 Date: 20151211 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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									002 see attachment
151	Pick Kit	0.00							
151									
packaging	Memo	0.00							
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									

MCS DEC 14 2015

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PAGE 1 OF 1

Part Number: D407-559-115

Description: BEARPAW INSTALLATION

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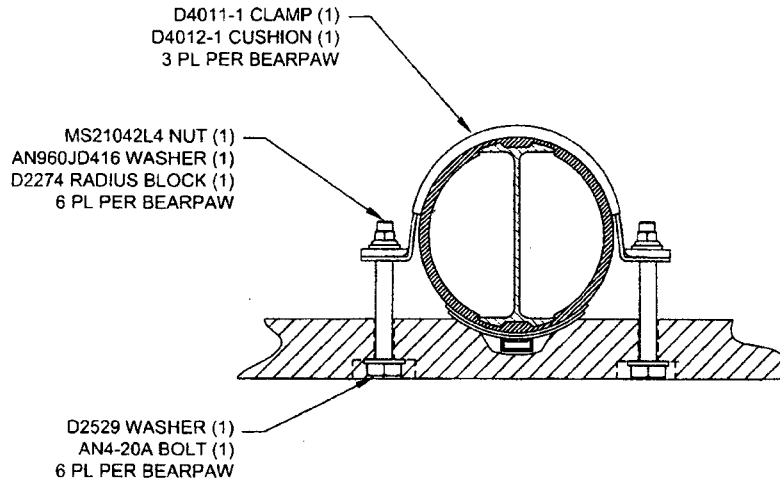


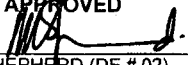
Figure 2 - D4011-1 Clamp Installation

4.0 PARTS LIST

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12	D2529	WASHER
2	D2432-3	BEARPAW
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6	D4012-1	CUSHION
12	AN4-20A	BOLT
12	AN960JD416	WASHER (NAS1149D0463J)
12	MS21042L4	NUT

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